

ORIGINAL PATENT APPLICATION BASED ON:

Docket: 87472

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**CONTAINER FOR INHIBITING MICROBIAL GROWTH IN LIQUID
NUTRIENTS**

EXPRESS MAIL LABEL NO.: EV293509068US

Date of Mailing: April 13, 2004

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NUTRIENTS

5 **CROSS REFERENCE TO RELATED APPLICATIONS**

Reference is made to commonly assigned U.S. Patent Application Serial No. _____ filed herewith entitled ARTICLE FOR INHIBITING MICROBIAL GROWTH by Joseph F. Bringley, David L. Patton, Richard W. Wien, Yannick J. F. Lerat (docket 87834); U.S. Patent Application Serial No. _____ filed herewith entitled USE OF DERIVATIZED NANOPARTICLES TO MINIMIZE GROWTH OF MICRO-ORGANISMS IN HOT FILLED DRINKS by Richard W. Wien, David L. Patton, Joseph F. Bringley, Yannick J. F. Lerat (docket 87471); U.S. Patent Application Serial No. _____ filed herewith entitled ARTICLE FOR INHIBITING MICROBIAL
10 GROWTH IN PHYSIOLOGICAL FLUIDS by Joseph F. Bringley, David L. Patton, Richard W. Wien, Yannick J. F. Lerat (docket 87833); U.S. Patent Application Serial No. _____ filed herewith entitled DERIVATIZED NANOPARTICLES COMPRISING METAL-ION SEQUESTRANT by Joseph F. Bringley (docket 87428); and U.S. Patent Application Serial No. _____
15 filed herewith entitled COMPOSITION OF MATTER COMPRISING POLYMER AND DERIVATIZED NANOPARTICLES by Joseph F. Bringley, Richard W. Wien, Richard L. Parton (docket 87708), U.S. Patent Application Serial No. _____ filed herewith entitled COMPOSITION COMPRISING INTERCALATED METAL-ION SEQUESTRANTS by Joseph F. Bringley,
20 David L. Patton, Richard W. Wien (docket 87765), the disclosures of which are incorporated herein by reference.

FIELD OF THE INVENTION

30 The present invention relates to a fluid container having a metal-ion sequestering agent for removing a designated metal ion from a liquid nutrient for inhibiting growth of microbes in the liquid nutrient.

BACKGROUND OF THE INVENTION

It has been recognized that small concentrations of metal ions play an important role in biological processes. For example, Mn, Fe, Ca, Zn, Cu and Al are essential bio-metals, and are required for most, if not all, living systems.

5 Metal ions play a crucial role in oxygen transport in living systems, and regulate the function of genes and replication in many cellular systems. Calcium is an important structural element in the life of bacteria regulating enzyme activity. Mn, Cu and Fe are involved in metabolism and enzymatic processes. At high concentrations, metals may become toxic to living systems and the organism may
10 experience disease or illness if the level cannot be controlled. As a result, the availability, and concentrations; of metal ions in biological environments is a major factor in determining the abundance, growth-rate and health of plant, animal and micro-organism populations.

It has also been recognized that iron is an essential biological
15 element, and that all living organisms require iron for survival and replication. Although, the occurrence and concentration of iron is relatively high on the earth's surface, the availability of "free" iron is severely limited by the extreme insolubility of iron in aqueous environments. As a result, many organisms have developed complex methods of procuring "free" iron for survival and replication.

20 Articles, such as food and beverage containers are needed that are able to improve food quality, to increase shelf-life, to protect from microbial contamination, and to do so in a manner that is safe for the user of such items and that is environmentally clean while providing for the general safety and health of the public. Materials and methods are needed to prepare articles having
25 antimicrobial properties that are less, or not, susceptible to microbial resistance. Methods are needed that are able to target and remove specific, biologically important, metal ions while leaving intact the concentrations of beneficial metal ions.

During the process of filling containers with certain beverages and
30 foods air borne pathogens enter the containers after the flash pasteurization or pasteurization part of the process. These pathogens such as yeast, spores, bacteria, etc. will grow in the nutrient rich beverage or food ruining the taste or even

causing hazardous microbiological contamination. While some beverages are packaged by aseptic means or by utilizing preservatives, many other beverages, for example fruit juices, teas and isotonic drinks are "hot-filled". "Hot-filling" involves the filling of a container with a liquid beverage having some elevated
5 temperature (typically, at about 180-200° F). The container is capped and allowed to cool, producing a partial vacuum therein. The process of hot filling of beverages and foods is used to kill the pathogens, which enter the container during the filling of the beverage or food containers. Hot filling requires containers be made of certain materials or constructed in a certain fashion such as thicker walls
10 to withstand the hot filling process. The energy required for hot filling adds to the cost of the filling process. Temperatures required for hot filling have a detrimental effect on the flavor of the beverage. Other methods of filling such as aseptic filling require large capital expenditures and maintaining class 5 clean room conditions.

15 US 5,854,303 discloses a polymeric material incorporating a polyvalent cation chelating agent in an amount effective to inhibit the growth of a protozoan on the surface of contact lenses and in other eye care products.

PROBLEM TO BE SOLVED BY THE INVENTION

20 The present invention is directed to the problem of the growth of micro-organism in liquids provided in containers that adversely affects food quality, shelf-life, to protect from microbial contamination, and to do so in a manner that is safe for the user of such.

SUMMARY OF THE INVENTION

25 In accordance with one aspect of the present invention, there is provided a fluid container for containing a liquid nutrient having a pH equal to or greater than about 2.5, the container having an interior surface having a metal-ion sequestering agent for removing a designated metal ion from the liquid nutrient
30 for inhibiting growth of microbes in the liquid nutrient.

In accordance with another aspect of the present invention, there is provided a method for inhibiting growth of microbes in a liquid, comprising the steps of;

- a. providing a container for holding a liquid having a pH equal to or greater than about 2.5, the container having an internal surface having an ion sequestering agent provided on at least a portion of the internal surface for removing a designated metal ion from the liquid;
- b. filling the container with the liquid in an open environment;
- c. closing the container with the liquid contained therein; and
- c. shipping the container for use of the liquid without any further processing of the container containing the liquid.

In accordance with still another aspect of the present invention, there is provide a method for bottling a liquid having a pH equal to or greater than about 2.5, comprising the steps of:

- a. providing a container having a sequestering agent provided on at least a portion of the internal surface for inhibiting growth of microbes;
- b. filling the container with a liquid having a pH equal to or greater than about 2.5; and
- c. sealing the container with the liquid contained therein.

In accordance with still another aspect of the present invention, there is provided an article for inhibiting the growth of a microbes in a liquid nutrient when placed in contact with the liquid nutrient, the article having a sequestering agent such that when the article is placed in contact with the liquid nutrient the sequestering agent inhibits the growth of microbes in the liquid nutrient, the sequestering agent comprising derivatized nanoparticles.

In accordance with another aspect of the present invention, there is provided a sealed fluid container for containing a liquid nutrient, the container having an interior surface having a metal-ion sequestering agent for removing a designated metal ion from the liquid nutrient for maintaining the level of microbes in the liquid nutrient below a predetermined amount.

In accordance with still yet another aspect of the present invention, there is provided a method of injection molding a multi-layer plastic preform to be blow molded into a container comprising the steps of:

forming an inner layer of a preform of a first plastic material
5 having an open end, sidewalls, and a closed end, the closed end having a plurality of spaced channels on the exterior surface thereof extending from a central area on the closed end to the sidewalls, the first plastic material includes a sequestering agent for inhibiting the growth of microbes;

providing an overmolding mold cavity defined by sidewalls, an
10 open end for accommodating a core rod, and a closed end with an injection gate there through, and a plurality of channels on the interior surface of the closed end communicating with the gate and extending from the gate to the sidewalls;

inserting a core rod and the inner plastic layer of the preform into the overmolding mold cavity with respective channels of the inner plastic layer of
15 the preform and the overmolding mold cavity substantially aligned; and

overmolding a second layer of a second plastic material on the inner plastic layer of the preform to form an overmolded multi-layer preform in the overmolding mold cavity by flowing the second plastic material from the gate only through the respective channels to the sidewalls of the overmolding mold
20 cavity thereby limiting the second material in the closed end of the multi-layer preform to regions of the channels,

providing internal pressure to the preform so as to form a container wherein the first plastic provides a surface for inhibiting the growth microbes with respect to a liquid placed in the container.

25 In accordance with yet still another aspect of the present invention, there is provided a method of making a bottle having metal-ion sequestering agent, comprising the steps of:

forming an inner layer of a plastic material having an open end, sidewalls, and a closed end, the closed end having a plurality of spaced channels
30 on the exterior surface thereof extending from a central area on the closed end to the sidewalls, the plastic material includes a sequestering agent for inhibiting the growth microbes;

providing an overmolding mold cavity defined by sidewalls, an open end for accommodating a core rod, and a closed end with an injection gate there through, and a plurality of channels on the interior surface of the closed end communicating with the gate and extending from the gate to the sidewalls;

5 inserting a core rod and the inner plastic layer of the preform into the overmolding mold cavity with respective channels of the inner plastic layer of the preform and the overmolding mold cavity substantially aligned; and

 providing internal pressure to the preform so as to form a container wherein the first plastic provides a surface for inhibiting the growth microbes with
10 respect to a liquid placed in the container.

 In accordance with another aspect of the present invention, there is provided a method of making a plastic container capable of inhibiting the growth of microbes in a liquid placed in the container, comprising the steps of:

 a. forming a plastic container having sidewall, an open end
15 and a closed end that form a receiving chamber for holding a fluid, said chamber defining an interior surface of the container; and

 b. applying a sequestering agent on the interior surface.

 In accordance with yet still another aspect of the present invention, there is provided a method of making a sealed package capable of inhibiting the
20 growth of microbes in a liquid placed in the container, comprising the steps of:

 a. forming the sealed container from at least one ply layer of a sheet material, the sheet material of one of the at least one ply layer having a interior side that will form the interior surface of the sealed package;

 b. providing a sequestering agent on the interior side.

25 In accordance with still yet another aspect of the present invention, there is provided a bottle and cap assembly for containing a liquid nutrient having a pH equal to or greater than about 2.5, the bottle having an interior surface having a metal-ion sequestering agent for removing a designated metal ion from the liquid nutrient for inhibiting growth of microbes in the liquid nutrient.

30 These and other aspects, objects, features and advantages of the present invention will be more clearly understood and appreciated from a review

of the following detailed description of the preferred embodiments and appended claims and by reference to the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

5 In the detailed description of the preferred embodiments of the invention presented below, reference is made to the accompanying drawings in which:

 Figure 1 illustrates a cross section of a fluid container made in accordance with the prior art;

10 Figure 2 is an enlarged partial cross sectional view of a portion of the container of Fig. 1 illustrating a “free” iron ion sequestering agent;

 Figure 3 is a view similar to Figure 2 illustrating a container made in accordance with the present invention;

 Figure 4 illustrates a bottle with a bottle cap also made in
15 accordance with the present invention;

 Figure 5 is a schematic top plan view of the bottle and cap of Fig.
4;

 Figure 6 is an enlarged partial cross sectional view of the bottle and cap taken along line 6-6 of Fig. 5;

20 Figure 7 is a schematic view of a projecting member extending from a modified cap of Figure 5 also made in accordance with the present invention;

 Figure 8 is an enlarged cross sectional view of the projecting member of Fig. 7 as taken along line 8-8;

25 Figure 9 is a schematic view of another embodiment of the present invention illustrating one method for applying a coating to the interior surface of a bottle made in accordance with the present invention;

 Figure 10 is an enlarged partial cross sectional view of a portion of the bottle of Fig. 9 illustrating the sprayed coating of the ion sequestering agent;

30 Figure 11 is a schematic view of another fluid container made in accordance with the present invention such as a juice box ;

Figure 12 is an enlarged partial cross sectional view of the juice box taken along line 12-12 of Fig. 11;

Figure 13 is a schematic view of yet another fluid container such as a stand up pouch made in accordance with the present invention;

5 Figure 14 is an enlarged partial cross sectional view of the stand up pouch taken along line 14-14 of Fig. 13;

Figure 15 is a schematic view of still another embodiment of a fluid container such as a bag also made in accordance with the present invention;

10 Figure 16 is an enlarged partial cross sectional view of a portion of the bag of Fig. 15 as indicated by circle 16;

Figure 17 is a cross-sectional view of a web that can be used in the manufacture of a box, pouch or bag showing a coating assembly for coating a hydrophilic layer containing a metal-ion sequestering agent;

15 Figure 18 is a schematic view of yet another fluid container, such as a can, made in accordance with the present invention;

Figure 19 is a cross sectional view of Fig. 18 as taken along line 19-19;

Figure 20 is a cross sectional view of a filter assembly made in accordance with the present invention;

20 Figure 21 is a cross sectional view of a fluid bed ion exchange assembly made in accordance with the present invention; and

Figure 22 is an enlarged partial view of a portion of the fluid bed ion exchange assembly of Fig. 21 as identified by circle 22 illustrating a metal-ion sequestering agent.

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DETAILED DESCRIPTION OF THE INVENTION

The growth of microbes in an article such as a fluid container containing a liquid nutrient comprising a liquid nutrient can be inhibited by placing metal-ion sequestering agents, as described in U.S. Patent Application
30 Serial No. _____ filed herewith entitled DERIVATIZED
NANOPARTICLES COMPRISING METAL-ION SEQUESTRAINT by Joseph
F. Bringley (docket 87428), and U.S. Patent Application Serial No. _____

filed herewith entitled COMPOSITION OF MATTER COMPRISING
POLYMER AND DERIVATIZED NANOPARTICLES by Joseph F. Bringley et
al. (docket 87708) capable of removing a designated metal ion for example, Mn,
Fe, Ca, Zn, Cu and Al from said liquid nutrients, in contact with the nutrient.

5 Intimate contact is achieved by incorporating the metal-ion sequestering agent as
an integral part of the support structure of the article. For example, one can
control the concentration of “free” iron in the liquid nutrient held by the article by
placing an iron sequestering agent in the walls of the container, which in turn
controls the growth rates, and abundance of micro-organisms. The article, such as
10 a container, may be used for holding a food or beverage.

Metal-ion sequestering agents may be incorporated into articles by
placing the metal-ion sequestering agents on the surface of the article, or by
putting the metal-ion sequestering agents within the materials used to form the
article. In all instances, the metal-ion sequestering agents must be capable of
15 contacting the food or beverage held by the container.

Referring to Fig.1, there is illustrated a cross-sectional view of a
typical prior art container. In the embodiment illustrated, the container comprises
a bottle 5 holding a liquid nutrient 10, for example an isotonic liquid. Drinks such
as Gatorade TM or PowerAde TM are examples of isotonic drinks/liquids. The
20 container 5 may be made of one or more layers of a plastic polymer using various
molding processes known by those skilled in the art. Examples of polymers used
in the manufacture of bottles are PET (polyethylene terephthalate), PP
(polypropylene), LDPE (low density polyethylene) and HDPE (high density
polyethylene). Figure 2 illustrates a plastic bottle 5 formed using two different
25 polymeric layers 15 and 20. However it is to be understood that the container 5
may comprise any desired number of layers.

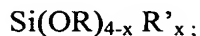
A fluid container made in accordance with the present invention is
especially useful for containing a liquid nutrient having a pH equal to or greater
than about 2.5. The container is designed to have an interior surface having a
30 metal-ion sequestering agent for removing a designated metal ion from a liquid
nutrient for inhibiting growth of microbes in said liquid nutrient. It is preferred
that the metal-ion sequestrant is immobilized within the materials forming the

container or is immobilized within a polymeric layer directly in contact with the beverage or liquid nutrient. It is further preferred that the metal-ion sequestering agent is immobilized on the surface(s) of said container. This is important because metal-ion sequestrants that are not immobilized may diffuse through the material or polymeric layers of the container and dissolve into the contents of the beverage. Metal ions complexed by dissolved sequestrants will not be sequestered within the surfaces of the container but may be available for use by micro-organisms.

It is preferred that the sequestering agent is immobilized on the surface(s) of said container and has a high-affinity for biologically important metal ions such as Mn, Zn, Cu and Fe. It is further preferred that the immobilized sequestering agent has a high-selectivity for biologically important metal ions such as Mn, Zn, Cu and Fe. It is preferred that said sequestering agent has a high-selectivity for certain metal ions but a low-affinity for at least one other ion. It is further preferred that said certain metal ions comprises Mn, Zn, Cu and Fe and said other at least one ion comprises calcium. This is preferred because some metal ions such as calcium, sodium and potassium may be beneficial to the taste and quality of the food, and are usually very highly abundant in foodstuffs and in liquid extrudates of foodstuffs. It is preferred that said metal-ion sequestering agent is immobilized on the surface(s) of said container and has a stability constant greater than 10^{10} with iron (III), more preferably greater than 10^{20} with iron (III), and most preferably greater than 10^{30} with iron (III). This is preferred because iron is an essential nutrient for virtually all micro-organisms, and sequestration of iron may most beneficially limit the growth of micro-organisms.

In a particularly preferred embodiment, the invention provides a fluid container wherein said metal-ion sequestering agent comprises derivatized nanoparticles comprising inorganic nanoparticles having an attached metal-ion sequesterant, wherein said inorganic nanoparticles have an average particle size of less than 200 nm and the derivatized nanoparticles have a stability constant greater than 10^{10} with iron (III). It is preferred that the inorganic nanoparticles have an average particle size of less than 100 nm. It is preferred that said metal-ion

sequestrant is attached to the nanoparticle by reacting the nanoparticle with a silicon alkoxide intermediate of the sequestrant having the general formula:



5

wherein x is an integer from 1 to 3;

R is an alkyl group; and

R' is an organic group containing an alpha amino carboxylate, a hydroxamate, or a catechol. Derivatized nanoparticles useful for practice of the invention are

10 described in detail in U.S. Patent Application Serial No. _____ filed herewith entitled DERIVATIZED NANOPARTICLES COMPRISING METAL-ION SEQUESTRAINT by Joseph F. Bringley (docket 87428) co-filed herewith

In a preferred embodiment the metal-ion sequestering agent is immobilized in a polymeric layer, and the polymeric layer contacts the fluid
15 contained therein. The metal-ion sequestrant may be formed integrally within the materials comprising the bottle or may be contained within a polymeric layer directly in contact with the beverage or liquid nutrient. It is preferred that the polymer is permeable to water. It is preferred that the metal-ion sequestering agent comprises are 0.1 to 50.0 % by weight of the polymer. Polymers useful for
20 practice of the invention are described in detail in U.S. Patent Application Serial No. _____ filed herewith entitled ARTICLE FOR INHIBITING MICROBIAL GROWTH by Joseph F. Bringley et al. (docket 87834).

In a preferred embodiment, the metal-ion sequestering agent comprises an alpha amino carboxylate, a hydroxamate, or a catechol functional
25 group. Metal-ion sequestrants suitable for practice of the invention include ethylenediaminetetraacetic acid (EDTA), ethylenediaminetetraacetic acid disodium salt, diethylenetriaminepentaacetic acid (DTPA), Hydroxylpropylenediaminetetraacetic acid (DPTA), nitrilotriacetic acid, triethylenetetraaminehexaacetic acid, N,N'-bis(o-hydroxybenzyl)
30 ethylenediamine-N,N' diacetic acid, and ethylenebis-N,N'-(2-o-hydroxyphenyl)glycine, acetohydroxamic acid, and desferroxamine B (the iron chelating drug desferal), catechol, disulfocatechol, dimethyl-2,3-

dihydroxybenzamide, mesitylene catecholamide (MECAM) and derivatives thereof, 1,8-dihydroxynaphthalene-3,6-sulfonic acid, and 2,3-dihydroxynaphthalene-6-sulfonic acid, and siderophores molecules naturally synthesized by micro-organisms which have a very high affinity for Fe. Metal-ion
5 sequestering agents suitable for use in the invention are described at length in U.S. Patent Application Serial No. _____ filed herewith entitled ARTICLE FOR INHIBITING MICROBIAL GROWTH by Joseph F. Bringley et al. (docket 87428).

Referring to Figure 3, there is illustrated an embodiment of a fluid
10 container 5 made in accordance with the present invention. The container 5, which in the embodiment illustrated is a bottle, is made of a material that comprises a barrier layer 22; an outer polymeric layer 20 and an inner polymeric layer 40 between said barrier layer 22 and outer polymeric layer 20. The inner polymeric layer 22 contains a metal-ion sequestrant 35. The barrier layer 22
15 preferably does not contain the metal-ion sequestrant 35. The outer layer 20 may provide several functions including improving the physical strength and toughness of the article and resistance to scratching, marring, cracking, etc. However, the primary purpose of the barrier layer 22 is to provide a barrier through which micro-organisms 25 present in the contained fluid cannot pass. It is important to
20 limit, or eliminate, in certain applications, the direct contact of micro-organisms 25 with the metal-ion sequestrant 35 or the layer containing the metal-ion sequestrant 35, since many micro-organisms 25, under conditions of iron deficiency, may bio-synthesize molecules which are strong chelators for iron, and other metals. These bio-synthetic molecules are called "siderophores" and their
25 primary purpose it to procure iron for the micro-organisms 25. Thus, if the micro-organism 25 are allowed to directly contact the metal-ion sequestrant 35, they may find a rich source of iron there, and begin to colonize directly at these surfaces. The siderophores produced by the micro-organisms may compete with the metal-ion sequestrant for the iron (or other bio-essential metal) at their surfaces.
30 However the energy required for the organisms to adapt their metabolism to synthesize these siderophores will impact significantly their growth rate. Thus, one object of the invention is to lower growth rate of organisms in the contained

liquid. Since the barrier layer 22 of the invention does not contain the metal-ion sequestrant 35, and because micro-organisms are large, the micro-organisms may not pass or diffuse through the barrier layer 22. The barrier layer 22 thus prevents contact of the micro-organisms with the polymeric layer 40 containing the metal-ion sequestrant 35 of the invention. It is preferred that the barrier layer 22 is permeable to water. It is preferred that the barrier layer 22 has a thickness "x" in the range of 0.1 microns to 10.0 microns. It is preferred that microbes are unable to penetrate, to diffuse or pass through the barrier layer 22. Sequestrant 35 with a sequestered metal ion is indicated by numeral 35'.

Still referring again to Figure 3, the enlarged sectioned view of the fluid container 5 shown in 3, illustrates a bottler having barrier layer 22, which is in direct contact with the liquid nutrient 10, an inner polymeric layer 40 and an outer polymeric layer 20. However, the bottle of Figure 2 comprises an inner polymeric layer 15 that does not contain any metal-ion sequestering agents. In the prior art bottle illustrated in Figure 2, the micro-organisms 25 are free to gather the "free" iron ions 30. In the example shown in Figure 3, the inner polymer 40 contains an immobilized metal-ion sequestering agent 35 such as EDTA. In order for the metal-ion sequestering agent 35 to work properly, the inner polymer 40 containing the metal-ion sequestering agent 35 must be permeable to aqueous media. Preferred polymers for layers 22 and 40 of the invention are polyvinyl alcohol, cellophane, water-based polyurethanes, polyester, nylon, high nitrile resins, polyethylene-polyvinyl alcohol copolymer, polystyrene, ethyl cellulose, cellulose acetate, cellulose nitrate, aqueous latexes, polyacrylic acid, polystyrene sulfonate, polyamide, polymethacrylate, polyethylene terephthalate, polystyrene, polyethylene, polypropylene or polyacrylonitrile. A water permeable polymer permits water to move freely through the polymer 40 allowing the "free" iron ion 30 to reach and be captured by the agent 35. An additional barrier 22 may be used to prevent the micro-organism 25 from reaching the inner polymer material 40 containing the metal-ion sequestering agent 35. Like the inner polymer material 40, the barrier layer 22 must be made of a water permeable polymer as previously described. The micro-organism 25 is too large to pass through the barrier 22 or the polymer 40 so it cannot reach the sequestered iron ion 30 now held by the

metal-ion sequestering agent 35. By using the metal-ion sequestering agents 35 to significantly reduce the amount of “free” iron ions 30 in the liquid nutrient 10, the growth of the micro-organism 25 is eliminated or severely reduced.

In the embodiment shown in Figures 4, 5, and 6 the metal-ion
5 sequestering agent 35 is contained in the bottle cap 50 instead on the inside surface of the bottle 5. An inner portion 45 of the cap 50, which is in intimate contact with the liquid nutrient 10 is made of a hydrophilic polymer 55 containing the metal-ion sequestering agent 35 such as EDTA as described above. In some situations, the bottle may need to be placed in the inverted position in order for the
10 sequestrant to become in contact with the contained nutrient. The cap 50 may also have the barrier layer 22 to further prevent the micro-organisms 25 from reaching the sequestered “free” iron 30. In another embodiment (not shown) the cap sealing material could be an open cell foamed structure whose cell walls are coated with the sequestering material.

15 In still another embodiment, the sequestering agent 35 may be in a hydrophilic polymeric insert 52 that is placed in the bottle 5 as illustrated in Figure 4. The insert 52 may be instead of or in addition to the sequestrant in the cap 50 or interior of the bottle. The insert 52 is placed in the bottle 5 but unfolds making it too large to exit the bottle 5. In another version, the insert 52 is molded
20 into the bottom of the bottle 5.

Referring to Figures 7 and 8, there is illustrated another modified embodiment of a container made in accordance with the present invention, like parts indicating like parts and operation as previously described. In this embodiment the metal-ion sequestering agent 35 is contained in a projecting
25 member 60 that extends from cap 50 into the bottle 5 so that it will be in intimate contact with the liquid nutrient 10. In the embodiment, the projecting member is in the configuration of a straw that can later be used to drink the liquid content in the bottle. Like the hydrophilic polymer material lining of the inside of the bottle 5 and bottle cap 50, the extension 60 or straw is made of a hydrophilic polymer 65
30 containing the metal-ion sequestering agents 35 such as EDTA as described in Figure 3. When the bottle 5 is filled with the liquid nutrient 10 such as an isotonic, and is capped, the straw 60 protrudes from the cap 50 into the solution 10

allowing the “free” iron ions 35 to be sequestered from the liquid nutrient liquid nutrient 10. The straw 60 may also have the barrier layer 22 to further prevent the micro-organisms 25 from reaching the sequestered “free” iron ions 30. The outer layer 20 may also be made of a material similar to barrier layer 22 so that “free” iron ions 30 can reach the sequestrant 35 from the outside of the straw 60.

In the example shown the extension is a straw, but the extension can be of any shape just as long as it extends into the food or beverage establishing intimate contact.

Referring to Figures 9 and 10, there is illustrated another embodiment of a bottle 5 made in accordance with the present invention. In this embodiment, the metal-ion sequestering agent 35 is applied to the inside surface 80 of the bottle 5 by spraying a metal-ion sequestering agent 35, for example EDTA, on to the inside surface of the bottle, through a supply tube 85 using a spherical shaped nozzle assembly 90. The nozzle assembly 90 is moved up and down in the direction of the arrow 95 while the metal-ion sequestering agent 35 is sprayed as indicated by the arrows 100. The method of applying coatings to glass, metal or plastic containers is well known to those skilled in the art. Figure 10 illustrates an enlarged partial cross sectional view of the portion of the bottle of Fig. 9 where the spray coating 105 of the ion sequestering agent 35 has been applied. As previously discussed in Fig. 3, like numerals indicate like parts and operations. It is of course understood that the inner layer containing the sequestrant may be applied or formed on the inside surface of the container in any appropriate manner. The bottle 5 in this embodiment may be made of any appropriate plastic or glass material.

Referring to Figures 11 and 12, there is illustrated yet another modified container 110 made in accordance with the present invention. In particular the container comprises juice/drink box 110 for containing a liquid beverage. The box 110 is made of a sheet material that comprises inner layer 115, a middle layer 120 made of a hydrophobic polymer material, and an outer layer 125. The inner layer 115 is in direct contact with the liquid nutrient 10 and is made of a hydrophilic polymer containing the metal-ion sequestering agent 35 such as EDTA as described above in Figure 3. As previously discussed in Fig. 3,

like numerals indicate like parts and operations. The outer layer 125 may comprise a foil wrap.

Referring to Figures 13 and 14, there is illustrated yet another modified embodiment of a container 130 made in accordance with the present invention. In the embodiment, the container comprises a stand up pouch 130. The pouch 130 comprises an inner layer 135 made of a hydrophilic polymer material, and an outer layer 140. The outer layer 140 may be made of a polymer such as Mylar™ with a metalized coating 145. The inner layer 135 is in direct contact with the liquid nutrient 10 and is made of a hydrophilic polymer containing the metal-ion sequestering agent 35 such as EDTA as described above in Figure 3. The stand up pouch 130 may also have the barrier layer 22 not shown to further prevent the micro-organisms 25 from reaching the sequestered “free” iron 30. As previously discussed in Fig. 3, like numerals indicate like parts and operations.

Referring to Figures 15 and 16, there is illustrated still another modified container made in accordance with the present invention. In this embodiment the container comprises a bag 150. The bag 150, which is intended to hold an aqueous material, comprises an inner layer 155 made of a hydrophobic polymer material, and an outer layer 160. The outer layer 140 may be made of a polymer such as polyethylene terephthalate. The inner layer 155 is in direct contact with the aqueous material 155 and is made of a hydrophilic polymer containing the metal-ion sequestering agent 35 such as EDTA as described above in Figure 3. The bag 150 may also have the barrier layer 22 not shown to further prevent the micro-organisms 25 from reaching the sequestered “free” iron 30. As previously discussed in Fig. 3, like numerals indicate like parts and operations.

The juice box 110, the pouch 130 and the bag 150 may be constructed from a base web 170 as illustrated in Figure 17. After the base web 170 is formed, the hydrophilic layer 175 is applied via a coating assembly 180 comprised of a reservoir 185, an applicator 190 and a drive mechanism not shown to form the hydrophilic inner layer 175 containing the metal-ion sequestering agent 35 as described above in Figure 3. Other methods of forming and of making webs and applying a coating such as coextrusion maybe used. It is of course

understood that any suitable technique or process may be used for applying a coating on supporting web as long as the coating has the appropriate sequestrant.

Referring to Figures 18 and 19 there is illustrated and modified container 220 made in accordance with the present invention. In this embodiment, the container 220 comprises a can. The can 200 is made of a metal material such as aluminum or steel, and has a top and a bottom, which may or may not be made as separate piece. The can 200 may also have a lining 205, which is in direct contact with the aqueous material 155 and intended to prevent corrosion of the metal by the contents of the can. The construction of metal cans is well known by one skilled in the art. The lining 205 may include a hydrophilic polymer containing the metal-ion sequestering agent 35 or have a hydrophilic polymer strip 210 containing metal-ion sequestering agent 35 made as part of lining 205 of the can 200. The strip 210 may have a width "w" of between 1 millimeter and 30 millimeters and be spaced at intervals around the inside circumference of the can 200 and a depth "d" of -1.0 to 10 micrometers. In still another embodiment, the sequestering agent 35 may be in a hydrophilic polymeric insert 52. The insert 52 is placed in the can 200 but unfolds making it too large to exit the can 200. The insert 52 may be simply placed on the bottom of the container or if desired secured to the interior surface of the container in some fashion. The metal-ion sequestering agent performs as previously described above in Figure 3.

Referring to Fig. 20, there is illustrated a cross-sectional view of a filter assembly 220 comprising an inlet port 225, an outlet port 230, and a filter 235. The filter 235 contains an immobilized metal-ion sequestering agent as previously described. As the solution flows through the filter assembly 220 in the direction indicated by the arrows 240, and through the filter 235 the metal ions in the solution are sequestered and removed by the metal-ion sequestering agent 245.

Referring to Figure 21, there is illustrated a cross sectional view of a fluid bed ion exchange assembly 250 comprising a holding tank 255, an inlet port 260, an outlet port 265, and a fluid bed 270 containing a metal-ion sequestering material 275 made in accordance with the present invention. The solution 280 flows into the fluid bed ion exchange assembly 250 via inlet port 260 as indicated by arrow 285 through the metal-ion sequestering material 275 in fluid

bed 270 as indicated by arrows 290 and out the outlet port as indicated by arrow 295.

Figure 22 is an enlarged partial view of a portion of the fluid bed 270 containing a metal-ion sequestering material 275. An example of the metal-ion sequestering material 275 comprises a core material 300 and a shell material 305 made of the metal-ion sequestering agent 35 as described in U.S. Patent Application Serial No. _____ filed herewith entitled ARTICLE FOR INHIBITING MICROBIAL GROWTH by Joseph F. Bringley et al. (docket 87428). As previously described above in Figure 21, the solution 280 containing “free” metal ions 310 flows through the fluid bed 270 as indicated by the arrows 315. As the solution 280 flows through the fluid bed 270 the shell material 305 made of the metal-ion sequestering agent 35 gathers the metal ions 320 removing them from the solution, which then flow out through the outlet port 265.

While in many of the embodiments illustrated, a barrier layer is not discussed, it is to be understood that a barrier layer 22 may be provided in any of the embodiments for preventing the microbes (micro-organism) from contacting the sequestrant..

The invention has been described in detail with particular reference to certain preferred embodiments thereof, but it will be understood that variations and modifications can be effected within the spirit and scope of the invention.

PARTS LIST

5	fluid container/bottle
10	liquid nutrient
15	inner polymeric layer
20	outer polymeric layer
22	barrier layer
25	micro-organism
30	“free” iron ion
35	metal-ion sequestering agents
35'	metal-ion sequestering agent with a sequestered metal ion
40	hydrophilic polymer
45	inner portion
50	bottle cap
52	insert
55	hydrophilic polymer
60	extension (straw)
65	hydrophilic polymer
80	inside surface
85	supply tube
90	spherical shaped nozzle assembly
95	arrow
100	arrow
105	spray coating
110	juice box
115	inner layer
120	middle layer
125	outer layer
130	pouch
135	inner layer
140	outer layer
145	coating

150	bag
155	aqueous material
160	inner layer
165	outer layer
170	base web
175	hydrophilic layer
180	coating assembly
185	reservoir
190	applicator
200	can
205	lining
210	strip
220	filter assembly
225	inlet port
230	outlet port
235	filter
240	arrow
250	fluid bed ion exchange assembly
255	holding tank
260	inlet port
265	outlet port
270	fluid bed
275	sequestering material
280	solution
285	arrow
290	arrow
295	arrow
300	core material
305	shell material
310	“free” metal ions
315	arrows
320	gathered metal ions